

Date: Monday, 11/08/2008 10:20:28 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SEAT BACK (AFT FACING LH/RH)		
Job Number	: 41085			Part Number	: D37743		
Estimate Number	: 13363			Drawing Number	: D3774 REV A/B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 11/08/2008	S.O. No.	:	Drawing Revision	: XB		
Prsht Rev.	: NC			Material	:		
First Issue	: 11/08/2008	Type	: THERMOFORMING	Due Date	: 28/08/2008		
Previous Run	: 40868			Qty:	10 Um: Each		
Written By	:			Wb. 08.11	11		
Checked & Approved By	: JUO 08.8.11			08.08.11	11		
Comment	: Est. REV:A New Issue 08.06.04 DL verified by:DD						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
Comment: HAND FINISHING THERMOFORMING Set up machine program D3774-3 Set up clamping frame as per folio		
2.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET
Comment: Qty.: 10.6670 sf(s)/Unit Total : 106.6700 sf(s) GE PLASTICS LEXAN SHEET batch: M105 330		
3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
Comment: HAND FINISHING THERMOFORMING 1) Cut Blanks		
4.0	THERMOFORMING	THERMOFORMING MACHINE
Comment: THERMOFORMING MACHINE Thermoform as per Dwg. D32811 and Folio FTA 011		
Dwg. Rev. <u>B</u> Folio Rev. _____		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/08/2008 10:20:28 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT BACK (AFT FACING LH/RH)

Job Number: 41085

Part Number: D37743

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BB 08/08/27 X 11

6.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 08/08/27 X 11

7.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT TRIMMED PARTS

1) Check dimensions to ensure conformity to drawing tolerances.

BB 08/08/28 X 11

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BB 08/08/28 X 11

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

6/8/27

BB 08/08/28 X 11

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/04 BB

Job Completion



MF 08-09-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41083
Description: SEAT BACK (AFT FACING)	Part Number:	037743
Inspection Dwg: 03774 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

#

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u> </u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB Date: 08/08/26

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100	1.31	✓			
1.9"	+/- 0.100	1.99	✓			
33.9"	+/- 0.100	33.9	✓			
.065"	MIN	.080	✓			
.085"	MIN	.130	✓			
.100"	MIN	134	✓			
.100"	MIN	131	✓			
.100"	MIN	125	✓			
.100"	MIN	142	✓			
.100"	MIN	119	✓			
.100"	MIN	137	✓			
.100"	MIN	118	✓			

Measured by: BB Date: 08/08/26

Audited by: J Date: 08/08/26

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	<u> </u>

DART AEROSPACE LTD	Work Order:	41085
Description: SEAT BACK (AFT FACING)	Part Number:	037743
Inspection Dwg: 03774 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1/8"</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 08/08/28

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100	1.305	✓			
1.9"	+/- 0.100	1.908	✓			
33.9"	+/- 0.100	33.9	—			
.0165"	MIN	.029	✓			
.085"	MIN	.098	✓			
.100"	MIN	.120	✓			
.100"	MIN	.132	—			
.100"	MIN	.127	—			
.100"	MIN	.133	—			
.100"	MIN	.125	✓			
.100"	MIN	.143	✓			
.100"	MIN	.116	✓			

Measured by: BB

Date: 08/08/28

Audited by: S

Date: 08/08/28

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

DART AEROSPACE LTD	Work Order:	41085
Description: SEAT BACK (AFT FACING)	Part Number:	037743
Inspection Dwg: 03774 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

#3

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1/8"</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 08/08/27

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	± 0.100	1.36	✓			
1.9"	± 0.100	1.93	✓			
33.9"	± 0.100	33.97	✓			
0.065"	MIN	.76	✓			
0.085"	MIN	1.04	✓			
0.100"	MIN	1.31	✓			
0.100"	MIN	1.48	✓			
0.100"	MIN	1.36	—			
0.100"	MIN	1.72	—			
0.100"	MIN	1.32	—			
0.100"	MIN	1.56	✓			
0.100"	MIN	1.37	✓			

Measured by: BB

Date: 08/08/27

Audited by: S

Date: 8/8/28

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

DART AEROSPACE LTD	Work Order:	41085
Description: SEAT BACK (AFT FACING)	Part Number:	037743
Inspection Dwg: 037741 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

#4.

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
<u>Inside Radii less than " "</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: TB

Date: 08/08/28

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	± 0.100	1.31	✓			
1.9"	± 0.100	1.96	✓			
33.9"	± 0.100	33.95	✓			
.065"	MIN	.086	✓			
.085"	MIN	.100	✓			
.100"	MIN	.135	✓			
.100"	MIN	.168	✓			
.100"	MIN	.140	✓			
.100"	MIN	.142	✓			
.100"	MIN	.133	✓			
.100"	MIN	.152	✓			
.100"	MIN	.141	✓			

Measured by: BB

Date: 08/08/28

Audited by: 

Date: 8/8/28

Prototype Approval:

Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

DART AEROSPACE LTD	Work Order:	41085
Description: SEAT BACK (AFT FACING)	Part Number:	037743
Inspection Dwg: 03774 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

#5

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>"</u>				
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching				

Measured by: BB

Date: 08/08/98

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	± 0.100	1.26	✓			
1.9"	± 0.100	1.91	✓			
33.9"	± 0.100	33.98	✓			
0.065"	MIN	.73	✓			
0.025"	MIN	.96	✓			
0.100"	MIN	117	/			
0.100"	MIN	168	/			
0.100"	MIN	149	/			
0.100"	MIN	120	/			
0.100"	MIN	126	/			
0.100"	MIN	140	✓			
0.100"	MIN	114	✓			

Measured by:

Date: 08/05/28

Audited by: ✓

Date: 8/4/28

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

DART AEROSPACE LTD	Work Order:	41085
Description: SEAT BACK (AFT FACING.)	Part Number:	037743
Inspection Dwg: 03774 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 1"				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 08/08/28

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	± 0.100	1.32	✓			
1.9"	± 0.100	1.96	✓			
33.9"	± 0.100	33.95	✓			
0.065"	MIN	0.74	✓			
0.085"	MIN	0.95	✓			
0.100"	MIN	1.14	✓			
0.100"	MIN	1.35	✓			
0.100"	MIN	1.28	✓			
0.100"	MIN	1.28	✓			
0.100"	MIN	1.21	✓			
0.100"	MIN	1.42	✓			
0.100"	MIN	1.38	✓			

Measured by: BB

Date: 08/08/28

Audited by: S

Date: 08/08/28

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

DART AEROSPACE LTD	Work Order:	4085
Description: SEAT BACK (AFT FACING)	Part Number:	037743
Inspection Dwg: 03774 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

#7

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1/8"</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 08/08/28

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	± 0.100	1.294	✓			
1.9"	± 0.100	1.86	✓			
33.9"	± 0.100	33.98	✓			
0.065"	MIN	.071	✓			
0.025"	MIN	.092	✓			
0.100"	MIN	108	✓			
0.100"	MIN	133	✓			
0.100"	MIN	118	✓			
0.100"	MIN	119	✓			
0.100"	MIN	119	✓			
0.100"	MIN	124	✓			
0.100"	MIN	109	✓			

Measured by: BB

Date: 08/08/28

Audited by: S

Date: 08/08/28

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

DART AEROSPACE LTD	Work Order:	41085
Description: SEAT BACK (AFT FACING.)	Part Number:	037743
Inspection Dwg: 03774 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

#8

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1/8"</u>				
Shape Definition	BB			
Texture Retention	BB			
Material imperfections such as bumps, cracks, voids, scratching	BB			

Measured by: BB

Date: 08/08/27

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100	1.28	✓			
1.9"	+/- 0.100	1.96	✓			
33.9"	+/- 0.100	33.92	✓			
.065"	MIN	.068	✓			
.085"	MIN	.094	—			
.100"	MIN	.129	—			
.100"	MIN	.173	—			
.100"	MIN	.136	—			
.100"	MIN	.129	—			
.100"	MIN	.126	—			
.100"	MIN	.155	—			
.100"	MIN	.134	—			

Measured by: BB

Date: 08/08/27

Audited by:

Date: 8/8/08

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

DART AEROSPACE LTD	Work Order:	41085
Description: SEAT BACK (AFT FACING.)	Part Number:	037743
Inspection Dwg: 03774 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

#9

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BD

Date: 08/08/28

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100	1.31	✓			
1.9"	+/- 0.100	1.929	✓			
33.9"	+/- 0.100	33.95	✓			
0.065"	MIN	.075	✓			
0.085"	MIN	.095	✓			
0.100"	MIN	1.23	✓			
0.100"	MIN	1.49	✓			
0.100"	MIN	1.50	✓			
0.100"	MIN	1.72	✓			
0.100"	MIN	1.27	✓			
0.100"	MIN	1.59	✓			
0.100"	MIN	1.35	✓			

Measured by: BD

Date: 08/08/28

Audited by: S

Date: 8/8/28

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

DART AEROSPACE LTD	Work Order:	41085
Description: SEAT BACK (AFT FACING)	Part Number:	037743
Inspection Dwg: 03774 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

10

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1/8"</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 08/08/28

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100	1.31	✓			
1.9"	+/- 0.100	1.93	✓			
33.9"	+/- 0.100	33.971	✓			
.0165"	MIN	.072	✓			
.025"	MIN	.100	✓			
.100"	MIN	1.37	✓			
.100"	MIN	1.44	✓			
.100"	MIN	1.29	✓			
.100"	MIN	1.50	✓			
.100"	MIN	1.40	✓			
.100"	MIN	1.60	✓			
.100"	MIN	1.40	✓			

Measured by: BB

Date: 08/08/28

Audited by: S

Date: 08/08/28

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

DART AEROSPACE LTD	Work Order:	41085
Description: SEAT BACK (AFT FACING)	Part Number:	037743
Inspection Dwg: 03774 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

11

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1/8"</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 08/08/28

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	± 0.100	1.30	✓			
1.9"	± 0.100	1.98	✓			
33.4"	± 0.100	33.98	✓			
0.065"	MIN	.074	✓			
0.085"	MIN	.095	✓			
0.100"	MIN	1.22	✓			
0.100"	MIN	1.24	✓			
0.100"	MIN	1.63	✓			
0.100"	MIN	1.57	✓			
0.100"	MIN	1.27	✓			
0.100"	MIN	1.53	✓			
0.100"	MIN	1.33	✓			

Measured by: BB

Date: 08/08/28

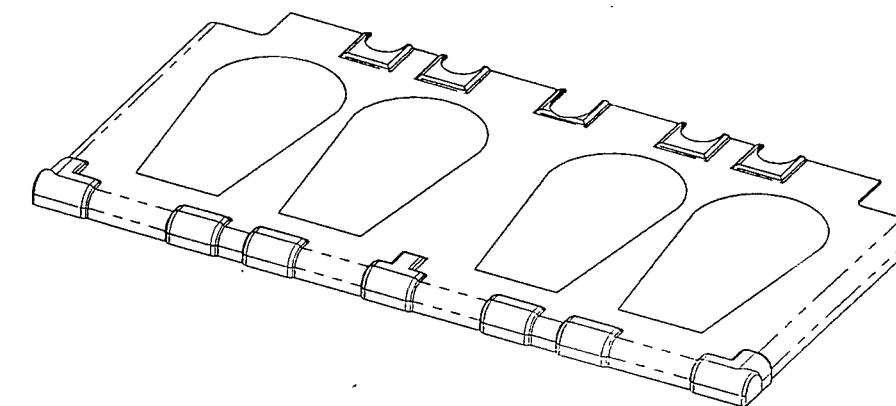
Audited by: S

Date: 08/08/28

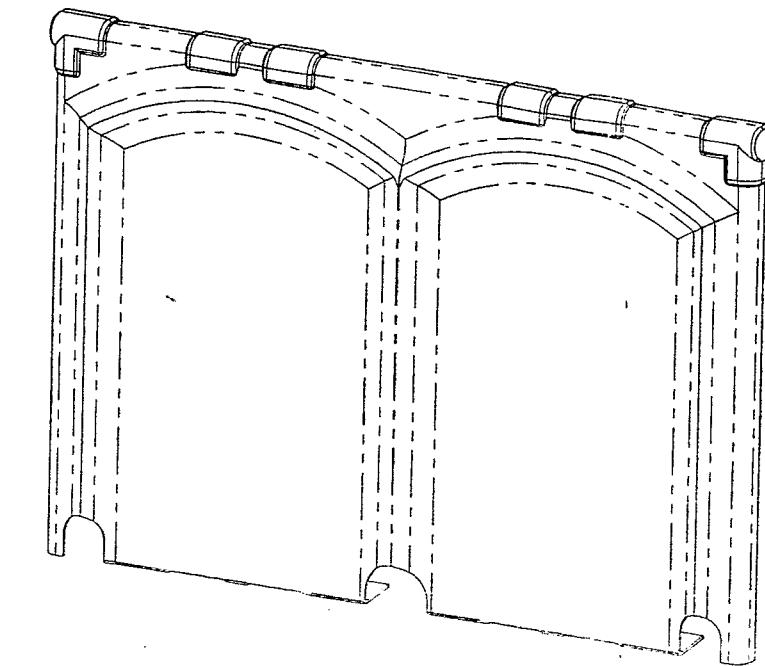
Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



D3774-1 SEAT BOTTOM

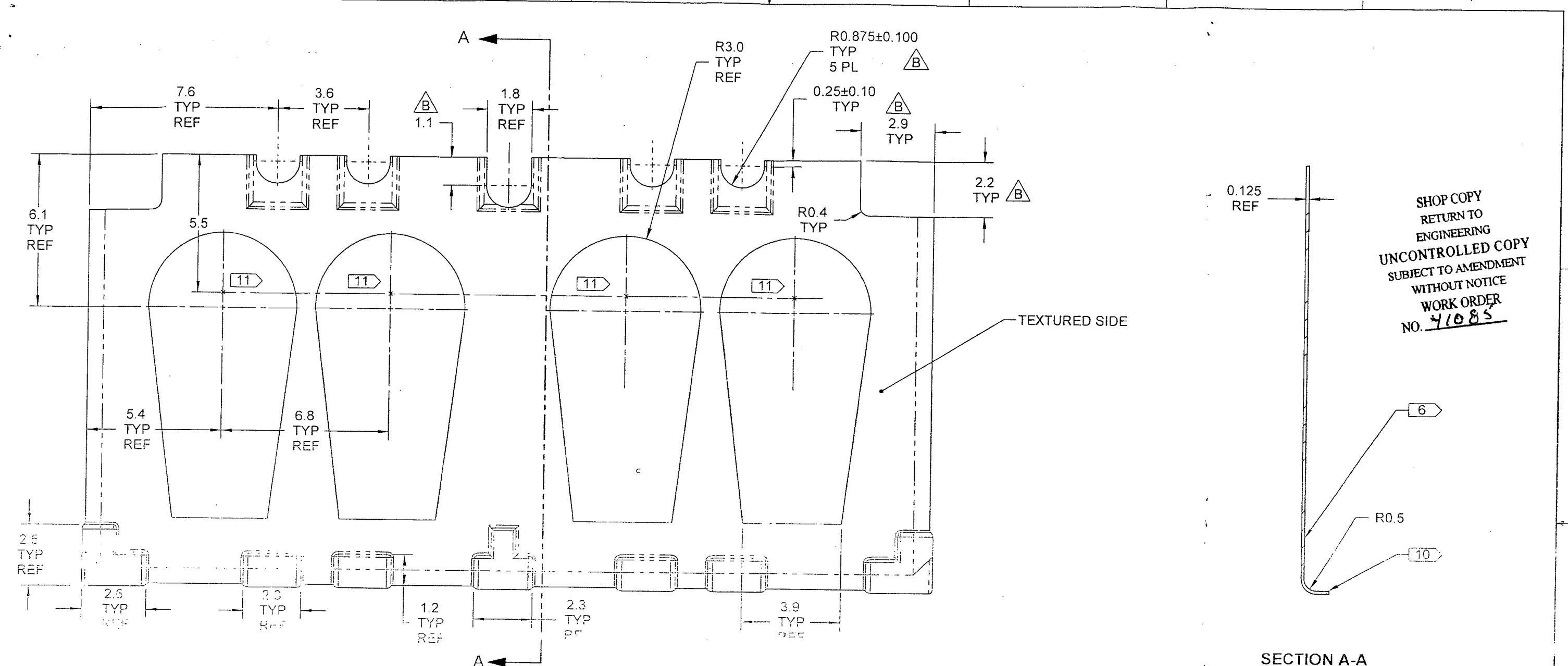


D3774-3 SEAT BACK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41085

RELEASED
08-07-25

B	UPDATE CUTCUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES	PH	08.07.25
A	NEW ISSUE	HS	08.06.23
REV.	DESCRIPTION		
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		D3774	REV. B
APPROVED		TITLE	SHEET 1 OF 3
DE APPR.		SEAT	SCALE
DATE	08.07.25	NTS	
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D3774-1 SEAT BOTTOM

NOTES:

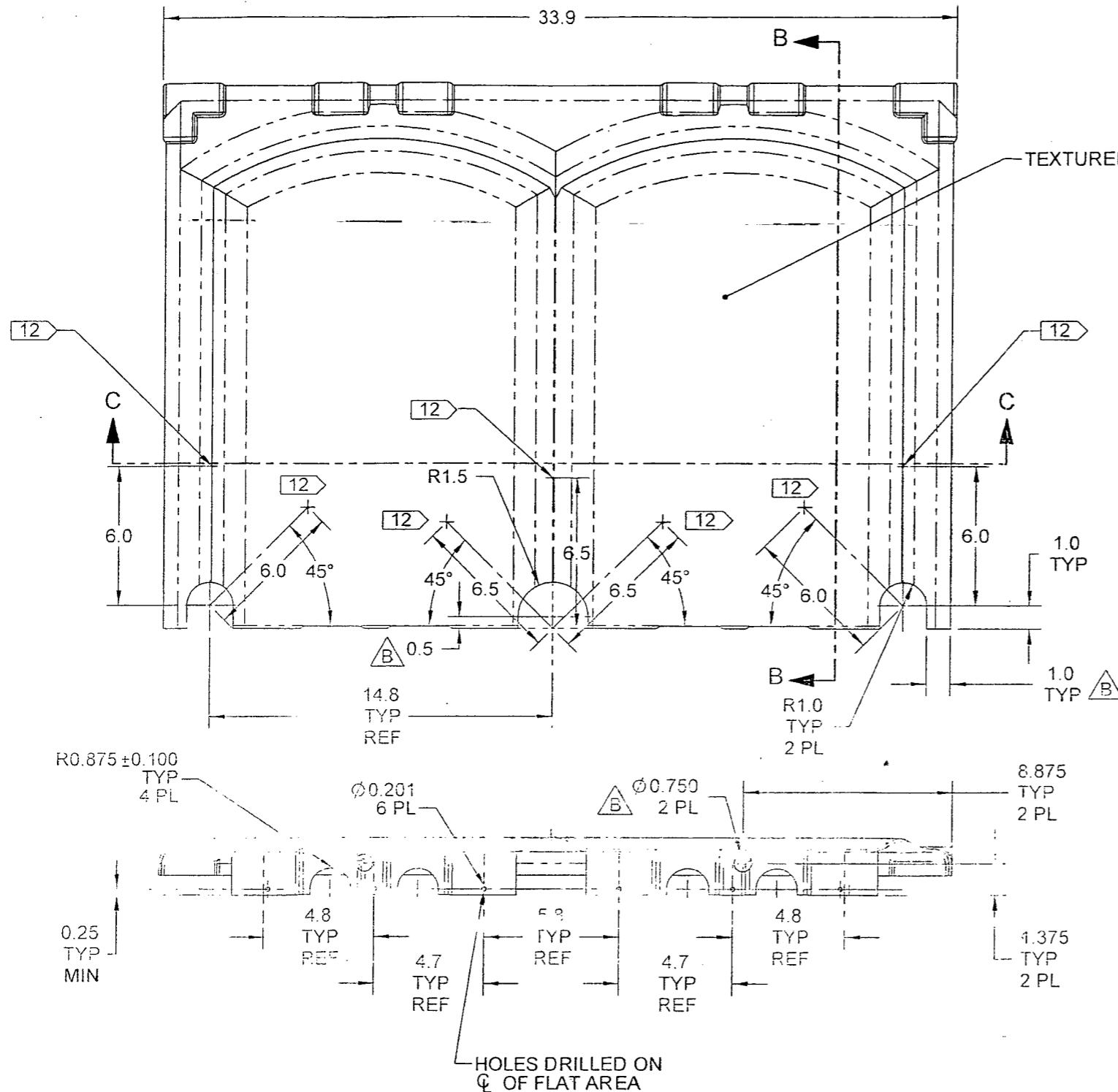
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-1" USING VIBRATING STYLUS
- 7) WEIGHT: 2.93 lbs
- 8) PART TO BE PRODUCED FROM MOLD DT9022 AND PER DART QSI 022
- 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9022
- 10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
- 11) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41085

SECTION A-A

RELEASED
08.08.11 M

DESIGN	HS	DART AEROSPACE LTD
DRAWN	<i>PA</i>	HAWKSLEY, ONTARIO, CANADA
CHECKED	<i>h</i>	DRAWING NO.
MFG. APPR.	<i>h</i>	REV. B
APPROVED	<i>h</i>	D3774
DE APPR.	<i>h</i>	SHEET 2 OF 3
DATE	08.07.25	TITLE
		SCALE
		NTS
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D3774-3 SEAT BACK

NOTES

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-3" USING VIBRATING STYLUS
- 7) WEIGHT: 4.82 lbs
- 8) PART TO BE PRODUCED FROM MOLD DT9023 AND PER DART QSI 022
- 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9023
- 10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON BOTTOM FLANGE IS 0.065
- 11) MINIMUM MATERIAL THICKNESS AFTER FORMING FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
- 12) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

